

Date: Tuesday, 7/11/2006 1:05:44 PM
User: Kim Johnston

Dart Aerospace Ltd.

Process Sheet

SPLIT 06/07/13

PTO

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT	
Job Number	: 27867A -1			Part Number	: D32781	
Estimate Number	: 10452			Drawing Number	: D3278 REV. B	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 7/11/2006		S.O. No. : N/A	Drawing Revision	: B	
Prsh Rev.	: NC			Material	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Due Date	: 7/30/2006	
Previous Run	: 27593A			Qty:	40	Um: Each
Written By	: See J comment below					
Checked & Approved By	: 06.07.11					
Comment	: Est:A 04.04.19 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
		Comment: Qty.: 0.4572 f(s)/Unit Total : 18.2868 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000)	M19059 / 2 PCS 42 Batch: M101000 / 17 PCS M18745 / 2 PCS 41 M15949 / 21 PCS J.F. 06/07/11
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long	J.F. 06/07/11 42
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1	42
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	42
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/07/13	4.	W/O split. Parts under tol. waiting for response. Qty 10	J	06-07-13	10		Z 06-07-13	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/12	3	1 piece that is too thin Not set well in the vise. 1 piece that the holes are .100" off. Didn't take the origin at the right place.	J R Z	2 parts scrap. destroy. No replace.	J.F. 06/07/12	Z 06-07-13	Z 06-07-13	Z 06-07-13

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes DQA:

Date: 06/07/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 7/11/2006 1:05:44 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 27867A

Part Number: D32781

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.F. 06/07/17

(30)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-07-24

(30)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57418

R.B. 06-25-07 (30)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(30)
R.B. 06-25-07 (30)

Job Completion



KJ 06.07.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27867A
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø,099"				
0.359	+/-0.005	,360"				
Ø0.119,609"	+/-0.010	1,615"				
0.250	+/-0.010	,251"				
1.480	+/-0.005	1,485"				
R0.125	+/-0.010	R,125"				
0.119	+0.005/-0.004	0,119"				
2.439	+/-0.010	2,439"				
1.980	+/-0.010	1,982"				
R0.130	+/-0.010	R0,130"				
Ø0.257	+0.005/-0.000	Ø,258"				
R0.375	+/-0.010	R,375"				
0.875	+/-0.010	0,876"				
0.500	+/-0.010	,500"				
R0.400	+/-0.010	R0,400"				
1.720	+/-0.010	1,722"				
R0.125	+/-0.010	R,125"				
0.125	+/-0.010	,127"				

Measured by:	J.F.	Audited by:	SD	Prototype Approval:	N/A
Date:	06/07/12	Date:	06.07.12	Date:	N/A

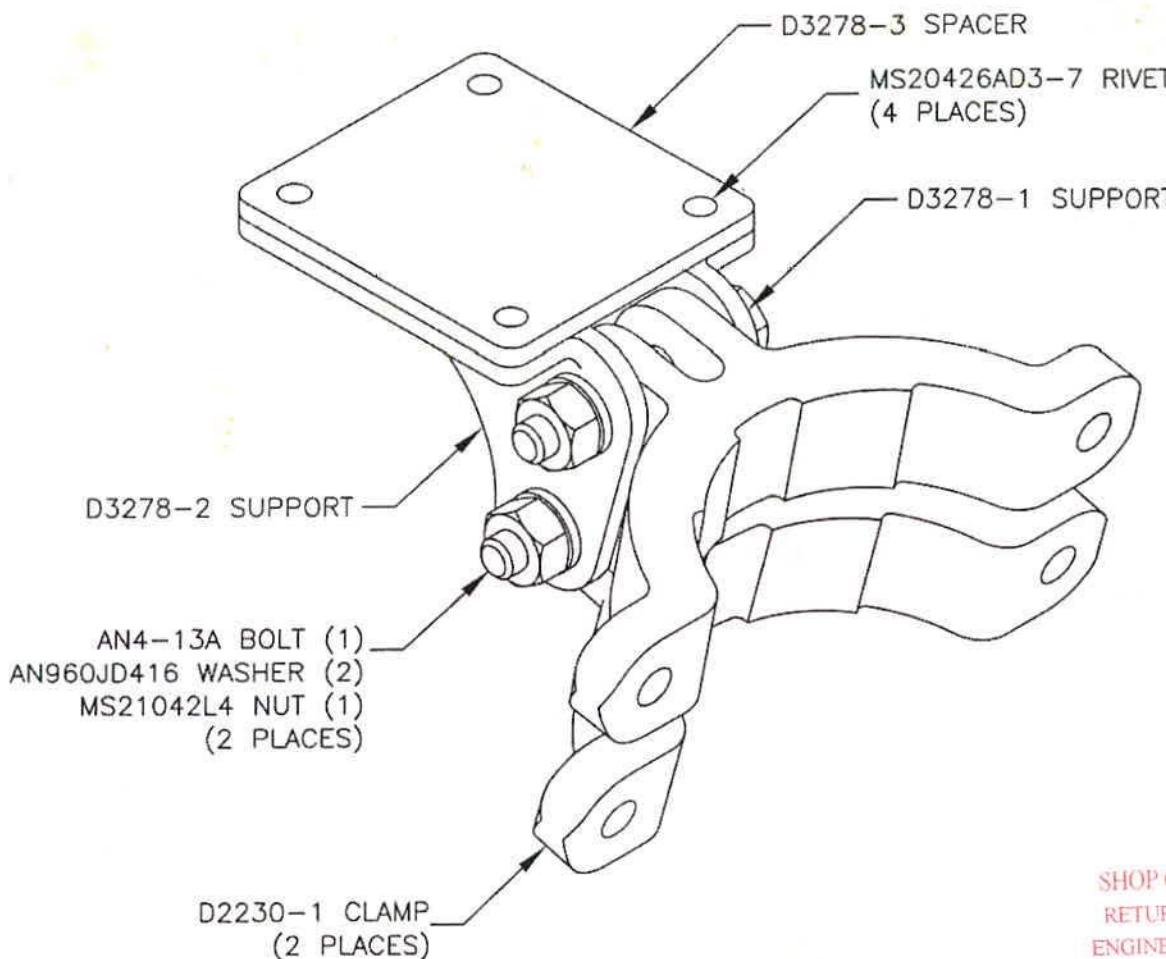
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	✓ JF

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[initials]*

D3278-041 SUPPORT ASSEMBLY



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WITHOUT NOTICE

WORK ORDER

NO. *27867A*

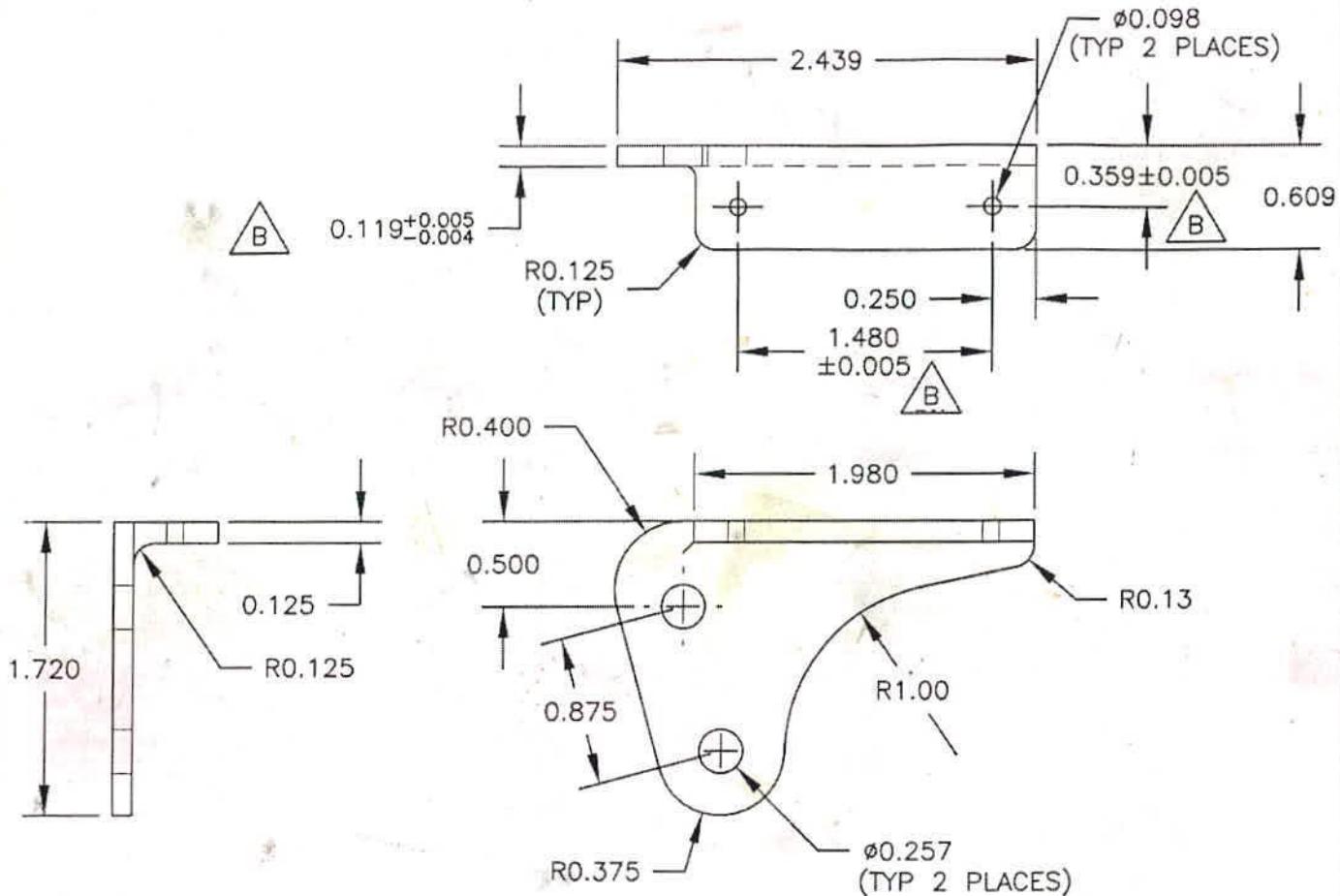
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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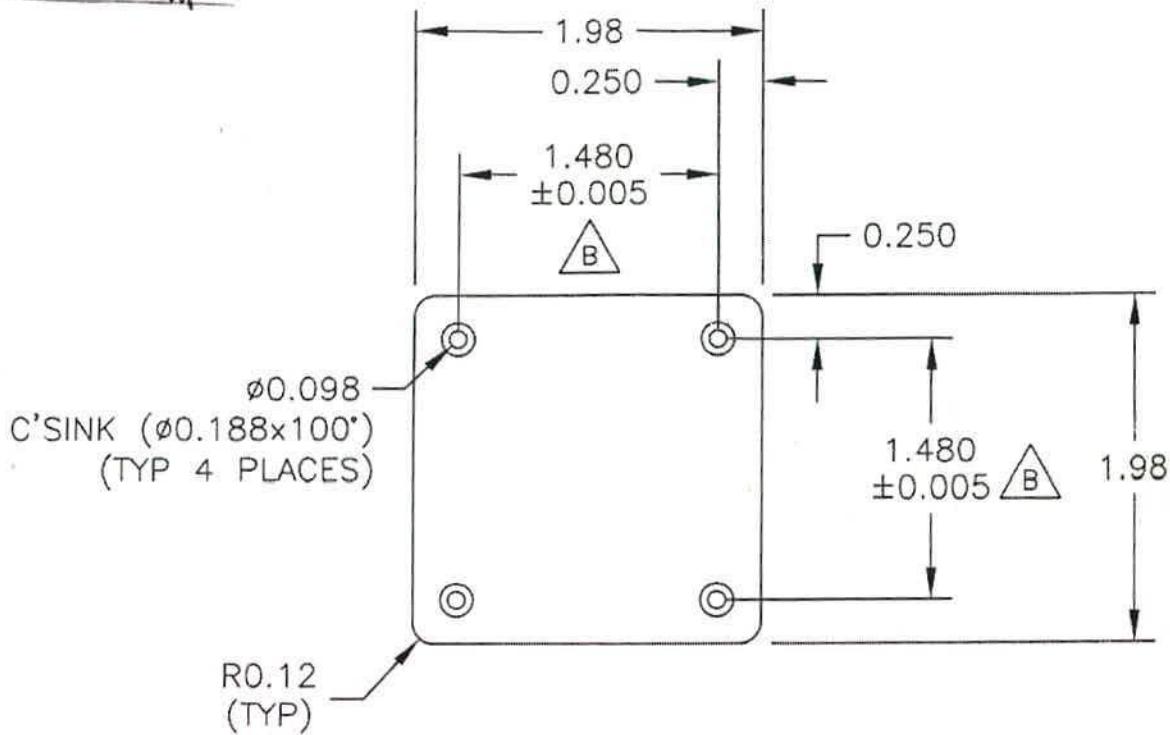
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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